

Date: Thursday, 5/3/2007 11:29:52 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	MOUNTING LUG			
Job Number	32163						
Estimate Number	10255						
P.O. Number	N/A		Part Number	D22301			
This Issue	5/3/2007	S.O. No.	N/A		Drawing Number	D2230 REV F	
Prsht Rev.	NC		Project Number	N/A			
First Issue	N/A	Type	MACHINED PARTS		Drawing Revision	F	
Previous Run	30992		Material	N/A			
Written By			Due Date	5/20/2007			
Checked & Approved By	<i>PH 07/05/03</i>		Qty:	170			
Comment	Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC					300	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
Comment:	Qty.: 0.0717 f(s)/Unit Total : 21.5145 f(s)	
	Lug Extrusion D2423 Extrusion	
	Batch: <i>30062</i>	<i>07/05/22</i>
2.0	BAND SAW	BAND SAW
Comment:	BAND SAW	
	Cut D2423 extrusion to 0.82"	
	Batch: _____	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment:	HAAS CNC VERTICAL MACHINING #1	
	1-Machine per folio D2230-1	
	(Check for crack while loading into the machine.)	
	2-Tumble and deburr rough edges after tumbling	
		<i>RG</i> <i>Issue P10-3812</i> <i>370</i> <i>07/05/20</i>
		<i>muchinereading</i> <i>D 2230 RCU.F</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<i>Received + inspect</i> <i>for turned damage</i>
5.0	QC5	SECOND CHECK
Comment:	SECOND CHECK	<i>J07-06-12</i> <i>170 counted</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MOUNTING LUG

Job Number: 32163

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HS

07-06-14

170

7.0 QC5

INSPECT WORK TO CURRENT STEP



ML 07 06 18

(170)

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M 104 144

170

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BL/M.L 07-06-18

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL

07/06/19

170

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54181

07/06/20 (170)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

Job Completion



W 07-06-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

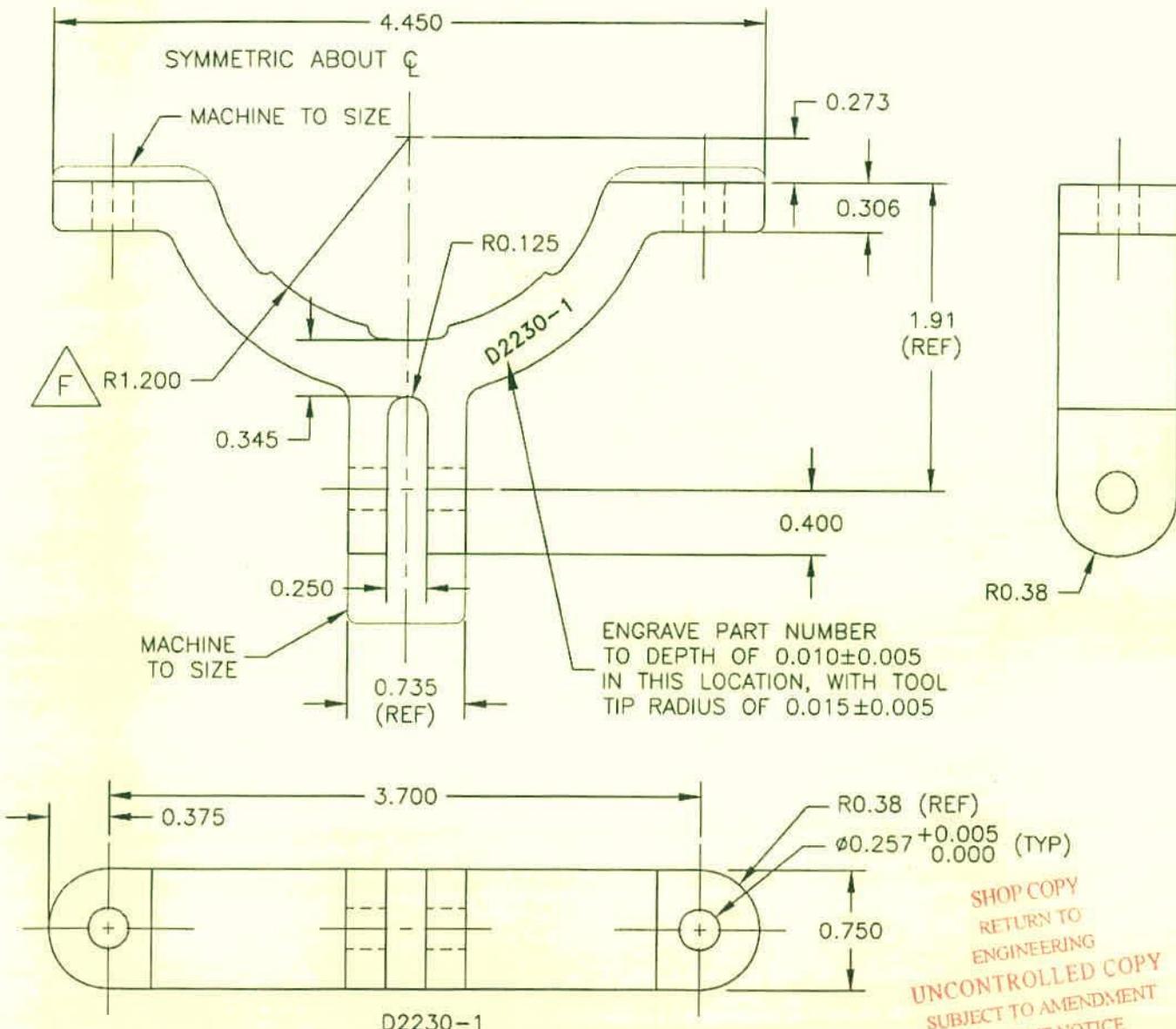
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

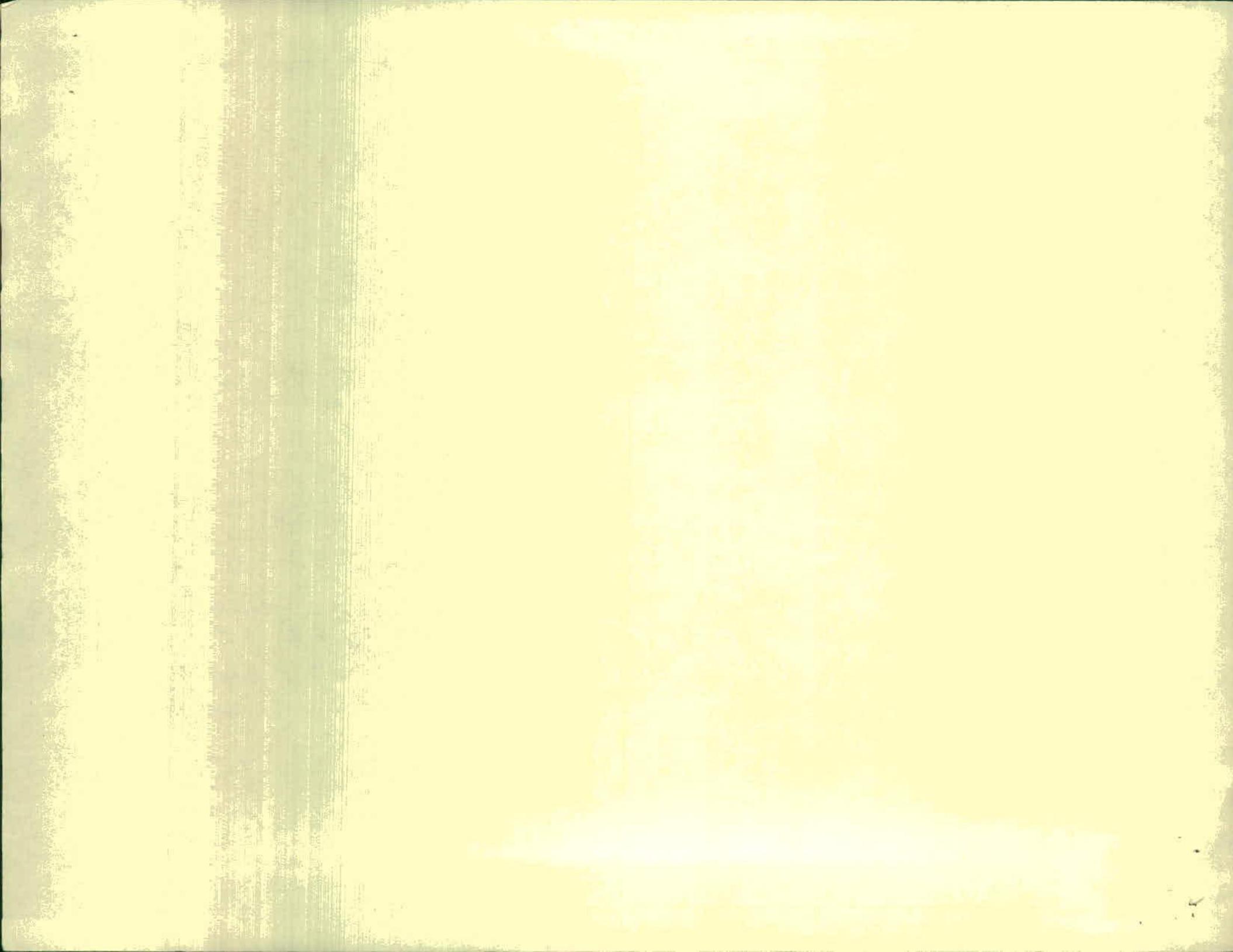
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

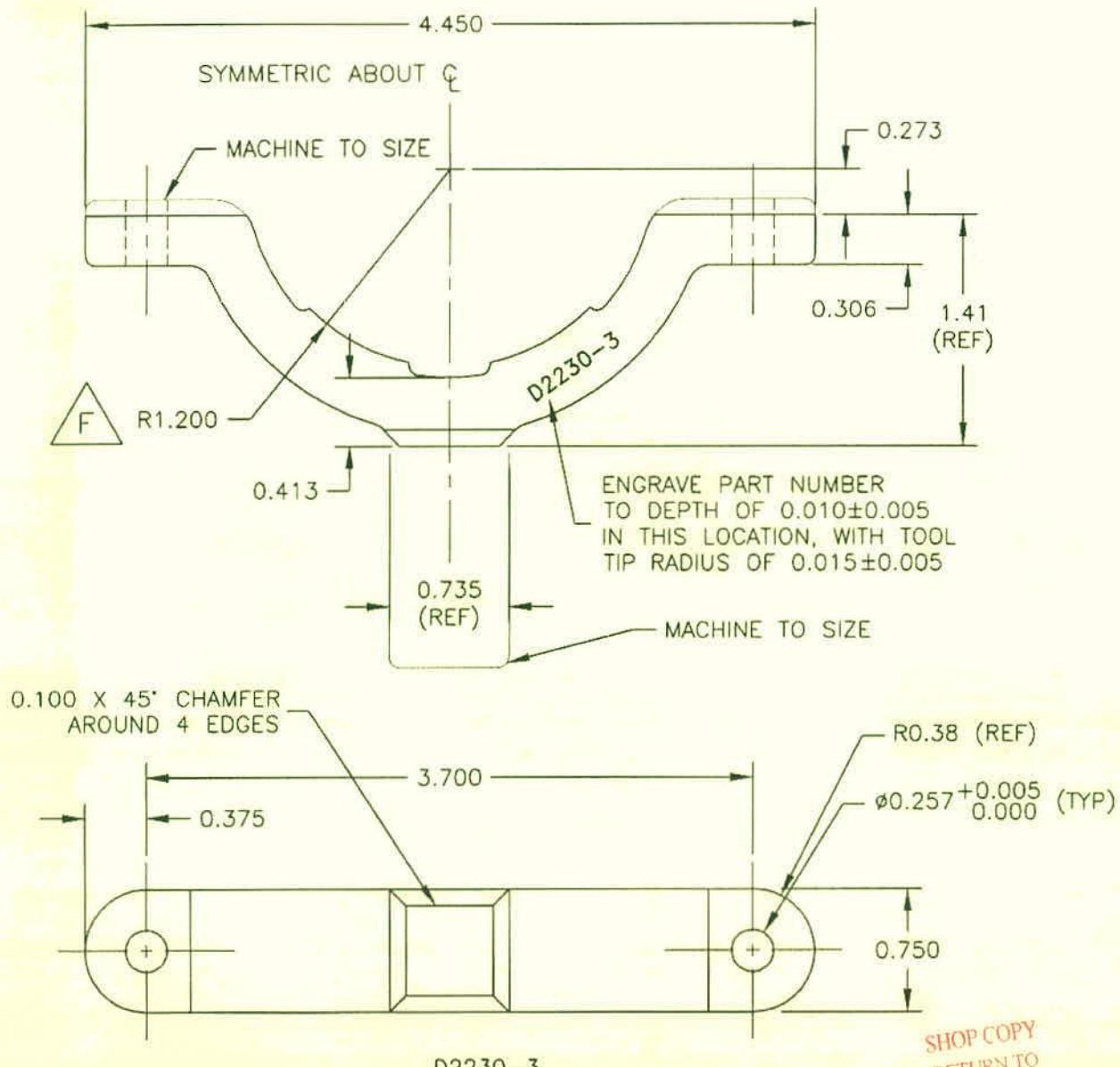
RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DARTCOPY ISSUED
04

DESIGN	GP	DRAWN BY	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	X	APPROVED	X	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE	99.12.13			TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32163





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
170	D2230-1	Lug B32163	3812

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shig (Regula) Walt

Vankleek Hill, June 12, 2007



